

Date: Tuesday, 19/05/2009 3:26:59 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 47994
 Estimate Number : 13292
 P.O. Number :
 This Issue : 19/05/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D37853
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3785 REVPREL
 Previous Run : 44540 Project Number : N/A
 Material :
 Due Date : 26/05/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : umf 09-05-19
 Comment : Est Rev:A 08-05-01 new issue -- DD verified by:EC
 Est Rev:B 09-01-09 rev.B as per dwg DD verified by:ec
 Est Rev:C 09-05-15 As per ECN09-593P JLM Verified
 By:EC

Additional Product

PRELIMINARY ISSUE

Job Number:



09-05-19

Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.2758 sf(s)/Unit Total: 0.2758 sf(s)

6061-T6 .080" Sheet

batch: 11063 B 9-5-21 B 9-5-28

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3785

Dwg Rev: PREProg Rev: Lim

****grain direction along 3.44****

2- Deburr if necessary B 9-5-21 B 9-5-28

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

ENGINEERING
APPROVAL

Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3785

P70
SB 09/05/28 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3785-3 PAR #: _____ Fault Category: Small Prob. NCR: Yes ☒ No ☐ DQA: / Date: 05-05-05
 Resolution: Scrap Disposition: other/Eng use only QA: N/C Closed: _____ Date: _____

NCR: 47994		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/05/27	5	1 piece was scrap out of tolerance Dwg not specific on dimensions. Too hard to calculate. RC: Prelim.	<u>/</u> 05/05/27	Scrap Qty 1 & replace. <u>M11063</u>	<u>B</u> 4-5-27	SB 09/05/28	<u>/</u> 05/05/28	<u>/</u> 05/05/28
09/05/27	5	1 part crack at the band RC: Process	<u>/</u> 05/05/27	Scrap - destroy NO replace Qty 1			<u>/</u> 05/05/28	<u>/</u> 05/05/28

NOTE: Date & initial all entries

Date: Tuesday, 19/05/2009 3:26:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 47994

Part Number: D37853

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-counter sink holes as per dwg D3785

FF

09-06-03

①

8.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

09-06-03

09-06-03

①

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MD

09/06/03

②

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m 109091

②

START TIME:

2:35

OVEN TEMPERATURE:

320°

FINISH TIME:

3:05

Fd

09/06/03

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BK 09-06-04

③

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location:

09-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/05/2009 3:26:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 47994

Part Number: D37853

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



~~POSITIVE RECALL~~

~~EFFECTIVE 01/05/20 AUTH L~~

~~RELEASED DATE~~

FOR ENG. USE
ONLY.

001.06.27

50 224A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47994
Description: BRACKET		Part Number: D3785-3
Inspection Dwg: D3785-3 Rev: PRE Lin		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .201	+ .005 - .001	.205	X -			
Ø .250	+ .005 - .001	.254	X -			
1.220	+/- .010	1.221	X ✓			
1.400	+/- .010	1.399	X ✓			
2.224	+/- .010	2.225	X -			
3.064	+/- .010	3.062	X ✓			
3.439	+/- .010	3.443	X -			
1.347	+/- .010	1.349	X ✓			
1.597	+/- .010	1.597	X			
2.000	+/- .010	2.003	X			
6.000	+/- .010	6.001	X			
6.750	+/- .010	6.752	X			
7.500	+/- .010	7.506	X			
8.847	+/- .010	8.843	X			
9.097	+/- .010	9.096	X			
1.080	+/- .010	1.078	X			

Measured by: IB	Audited by: [Signature]	Prototype Approval:
Date: 9-5-21	Date: 9-5-28	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8

7

2

1

CSK $\varnothing 0.385 \times 100^\circ$
FS

R0.20
2 PL

R0.25
TYP

3.439

3.064

2.224

1.400

1.220

1.001

0

R0.19
4 PL

1.597

1.347

0.502

0

80° 95°

PRELIMINARY ISSUE

09.05.12

PER ECN# C45938

1-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
F. DART SPEC. M6061T6S.080)
CAL CONVERSION COAT PER DART QSI 005 4.1
R COAT GREY SANDTEX (4.3.5.6) PER DART
4.3
PER DART QSI 018 UNLESS OTHERWISE NOTED
UNLESS OTHERWISE NOTED
EDGES: 0.005 TO 0.010 MAX
N: IDENTIFY WITH DART P/N "D3785-3" USING FINE
ENT INK MARKER

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3785

REV. C

SHEET 4 OF 5

TITLE

BRACKET

SCALE

NTS

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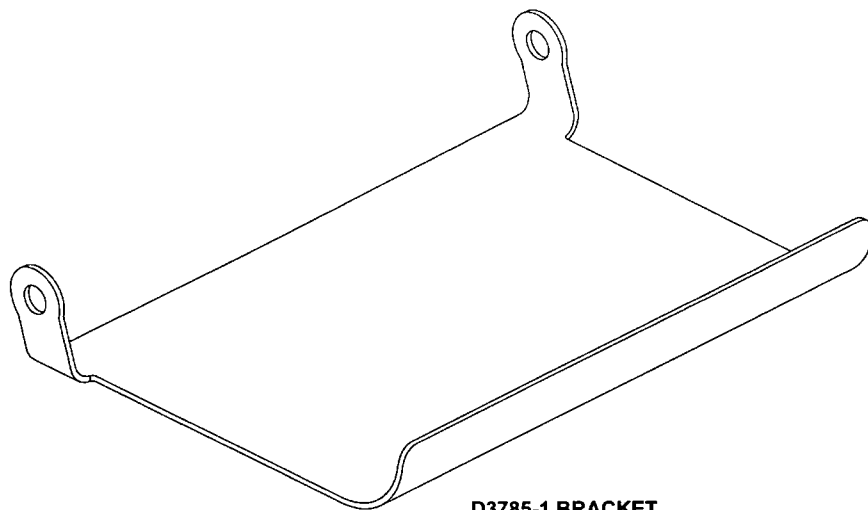
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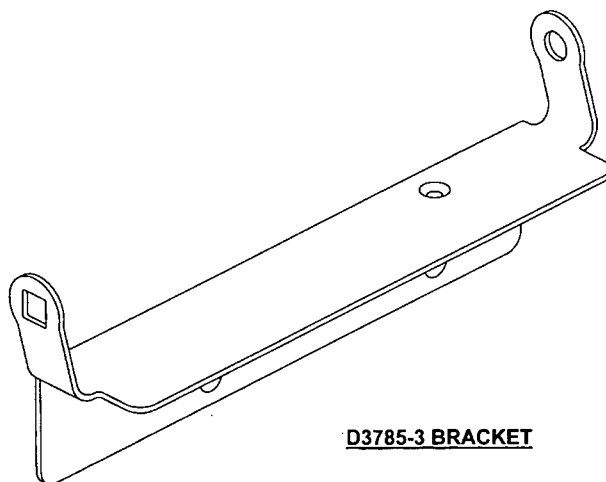
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1



D3785-1 BRACKET

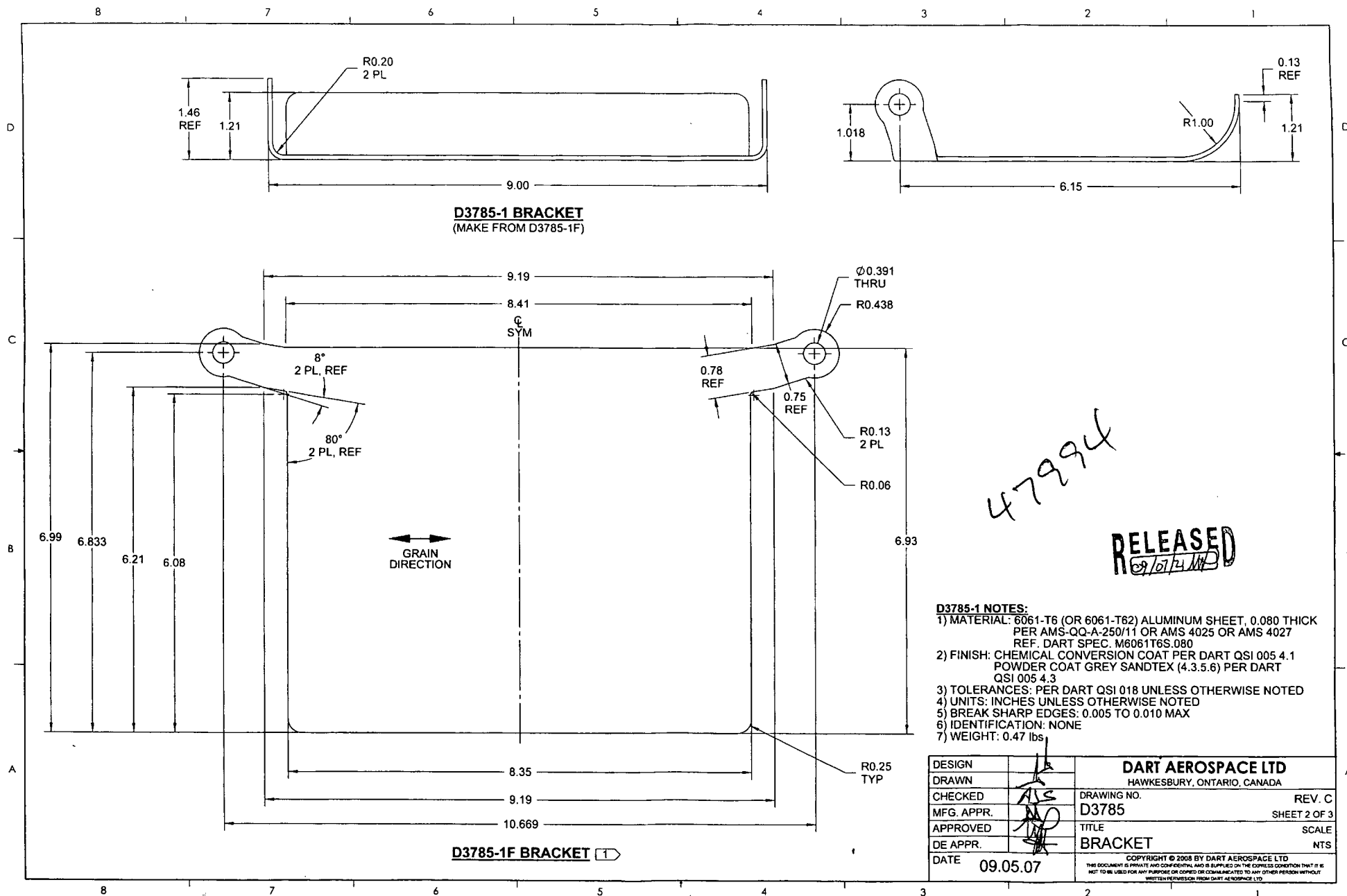


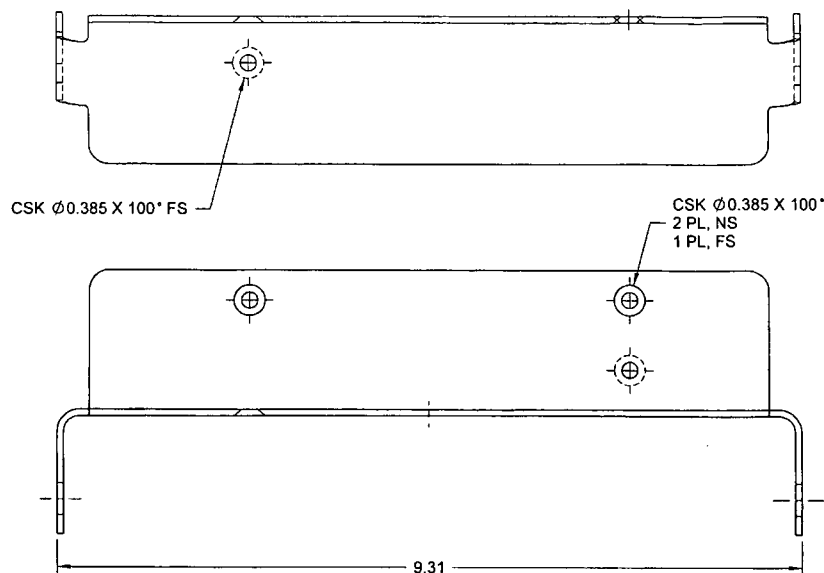
D3785-3 BRACKET

47994

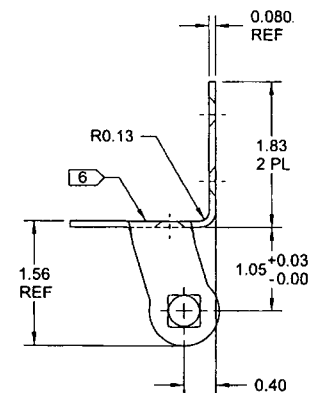
RELEASED
09/07/07

C	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.07
B	REDESIGNED D3785-3; REMOVED PINS D3785-041/-1/-5/-7; DRAWING TITLE WAS ARMREST WELDMENT REASON: ELIMINATED ARMREST FWD-AFT ADJUSTMENT; PARTS AND WELDMENT NO LONGER REQUIRED	MB	08.07.18
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.07		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3785 TITLE BRACKET SCALE NTS SHEET 1 OF 3 REV. C <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			



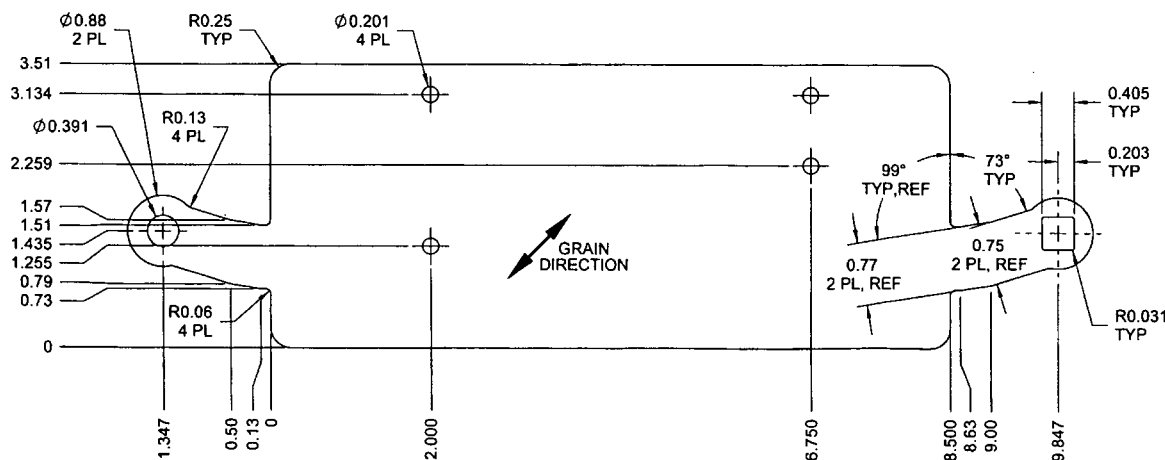


D3785-3 BRACKET
MAKE FROM D3785-3F



47994

RELEASED



D3785-3F FLAT PATTERN 1

D3785-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3785-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3785	SHEET 3 OF 3
MFG. APPR.		TITLE	SCALE
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